



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB6796941-14
Job Sheet 170013



Part No: RB6796941-14

Job Qty: 1 ea

Part Name: Starter Seal Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/8/18

Job Tracking No:

Due Date: 1/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Quantum Helicopters (CQUAN02)

2401 S Heliport Way Chandler, AZ, 85286 USA ph:(480) 814-8118 · fx:(480) 814-8737.

Note: RB6796941-14 rev.g IPP REV:A 18.01.05 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	4 Ea		1/11/18	0.00	0.00	Start Up Machining-4		SL 18-1-9
110	CNC Lathe	4 pcs		1/12/18	0.00	0.40	MORI SL-154		SL
120	QC	4 pcs		1/12/18	0.00	0.00	QC2 Machining-5		SL
130	QC	4 pcs		1/12/18	0.00	0.00	QC8 Machining-5		quant 18/01/18
135	QC	4 pcs		1/12/18	0.00	0.00	QC5		
140	Outsource	4 pcs		1/12/18	0.00	0.00	Outsource12		AT 18/01/18
150	Packaging	4 pcs		1/12/18	0.00	0.00	Packaging2		AT 18/01/18
160	QC	4 pcs		1/12/18	0.00	0.00	QC6		38
170	Packaging	4 pcs		1/12/18	0.00	0.00	Packaging3-2	GA	DAS 21 FEB 16 2018
180	QC21-SA	4 Ea		1/12/18	0.00	0.00	QC21		21

Part Op 110 - 1-Machine as per folio FB719 FOLIO REV: AA DWG REV: G 2-Debur

Descriptions: 135 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

140 - Issue P/O to Groupe Altech; PO 038918 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

0.13 JAN 31 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Start up Operation	MT-1144-R1.000	1	20	0	0

SG00809

.74

Part Specifications

Specifications could not be found.

Plex 1/8/18 9:05 AM Dart.lajeunesse.marie

DART
AEROSPACE
S030486

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7

CANADA

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Email: sales@dartaero.com

www.dartaerospace.com



Starter Seal Guide

PART NO: RB6796941 - 14

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 01/09/18

Job No: 170013



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

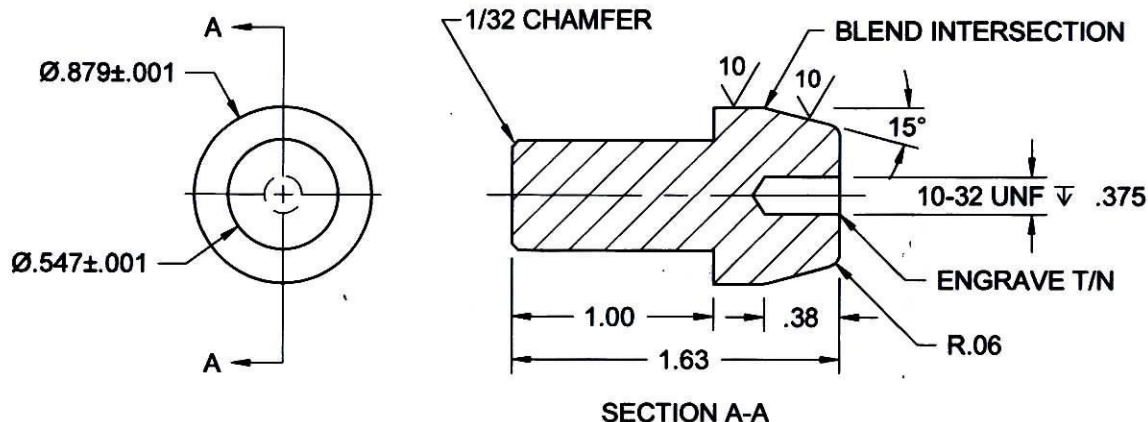
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
F	MADE INDIVIDUAL TOOL DWG. FROM KIT PER E.B.	7/15/11	RJC
G	ADDED ENGRAVE NOTE. ADDED MISSING 10-32 DIMENSION PER G.E.	10/24/11	RJC



(-14)
GUIDE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170013 MJS
18-01-08

NOTES

1. ALLISON T63-A-5 ACCESSORY GEARBOX.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
				1	GUIDE	SP	Ø1 x 1-3/4	

RED BARN MACHINE	
TITLE GUIDE	
DWG NO. RB6796941-14	REV G
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 XX ± .01 X ± .1	METRIC REF. .XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 7-17-00
SHEET 1 of 1	

DRAWN BY: COLE
APPROVED: *D. Med*
TREAT: BLACK OXIDE
FINISH: BLACK OXIDE
SPEC: SEE NOTE
USED ON MODEL



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038918**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038918
PO Date: 1/31/18
Due Date: 2/8/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

E-MAILED
FEB 12 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	169927	RBW6405G02131-3G-1	Bolt -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	2/8/18	2 pcs ✓	0 pcs 2x	2 pcs At 18/02/14	\$3.00/pcs	\$6.00
2	170013	RB6796941-14	Starter Seal Guide -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	2/8/18	5 pcs ✓	0 pcs 5x	5 pcs At 18/02/14	\$2.49/pcs	\$12.45
3	170165	647.7701	Strut Assembly Issue P/O : _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	2/8/18	10 pcs ✓	0 pcs 10x	10 pcs At 18/02/14	\$6.00/pcs	\$60.00
4	170255	RBT18560-11	Upright -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	2/8/18	12 pcs ✓	0 pcs 12x	12 pcs At 18/02/14	\$3.50/pcs	\$42.00
5	170360	RBW109-3101-58-1-3	Hammer Head -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	2/8/18	6 pcs ✓	0 pcs 6x	6 pcs At 18/02/14	\$2.39/pcs	\$14.34
6	170485	647.7703	Strut Assembly Issue	Firmed	2/8/18	16 pcs ✓	0 pcs 16x	16 pcs At 18/02/14	\$75.50/pcs	\$1,208.00



Certificat de Conformité / Certificate of Compliance

(006394-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

006394 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
14-Feb-2018		Curtis Anderson		038918				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6405G02131-3G-1 Rev.	BOLT 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***	ZINC CH	2	2	0	0	0
2	RB6796941-14 Rev.	PLUG BLACK OXIDE MIL-C-13924C CLASS 1	BLACK-OXIDE CH	5	5	0	0	0
3	647.7701 Rev.	647.7701 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE 2 CAD PLATE SHOULD NOT BE TO THICK AROUND TREAD	CADMIUM CH	10	10	0	0	0
4	RBT18560-11 Rev.	RBT18560-11 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	12	12	0	0	0
5	RBW109-3101-58-1-3 Rev.	RBW109-3101-58-1-3 01 -ZINC [ZINC] SPÉC: ASTM B633 TYPE 1, SC2 *** SPÉC: CONFORMITY IS REQ. ***	ZINC CH	6	6	0	0	0
6	647-7703 Rev.	647-7703 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE II	CADMIUM CH	16	16	0	0	0
7	RBW109-3101-58-1-3 Rev.	RBW109-3101-58-1-3 01 -ZINC [ZINC] SPÉC: ASTM B633 TYPE 1, SC2 *** SPÉC: CONFORMITY IS REQ. ***	ZINC CH	6	6	0	0	0
8	RBW6405G02131-3G-1 Rev.	BOLT 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***	ZINC CH	2	2	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.